

Date: Thursday, 7/19/2007 2:27:51 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 33672	
Estimate Number : 10283	
P.O. Number : <i>N/A</i>	Part Number : D31991
This Issue : 7/19/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3199 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33491	Material : <i>N/A</i>
Written By : _____	Due Date : 8/12/2007 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i> 07/07/19	
Comment : Est Rev: C Removed Scribing 05-11-05 JLM	
Est Rev: D As per Rev B 06-11-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.1040 sf(s)/Unit Total : 4.1580 sf(s)

304/316 0.040" SHEET

Batch: *M 102159*

5.512

LB 07-07-27

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3199

Dwg Rev: *B*

Prog Rev: *B*

LB 07-07-27

(53)

Deburr if required

SAD

07/07/30

53 counted

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



LB 07-07-27

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Sn

07/07/30

(53) counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per dwg D3199

SB 27/08/14 (53)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/08/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:27:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 33672

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

corrected
07/08/14 (53)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

104846
07/08/21 (53)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/8/22 SD

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/22 (53)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(53)

07/08/23

Job Completion



07-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33672
Description: Bracket		Part Number:	D3199-1
Inspection Dwg: D3199 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.210	+0.005/-0.001	.214	X			
0.575	+/-0.010	.575	X			
1.090	+/-0.010	1.090	X			
2.015	+/-0.010	2.015	X			
2.971	+/-0.010	2.971	X			
1.830	+/-0.010	1.828	X			
4.830	+/-0.010	4.830	X			
4.030	+/-0.010	4.030	X			

Measured by: HB	Audited by: SM	Prototype Approval:	N/A
Date: 07-07-27	Date: 07/07/30	Date:	N/A

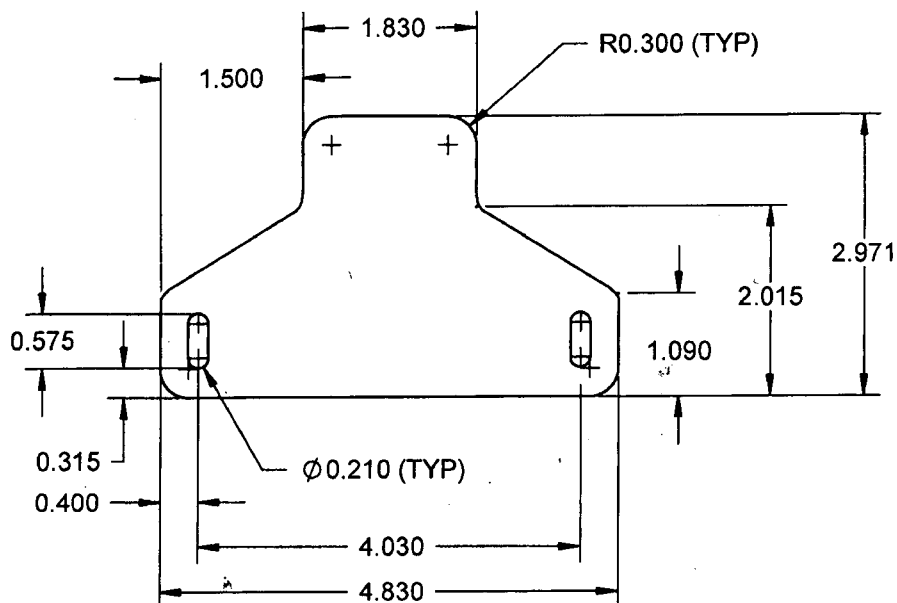
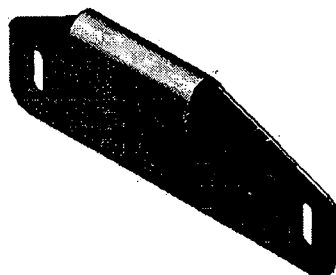
Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	BE



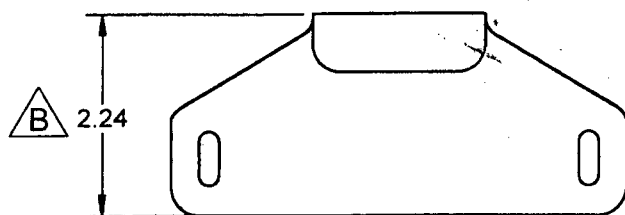
DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3199	REV. B SHEET 1 OF 1
DATE 06.11.01	TITLE BRACKET		SCALE 1:2
REV	DATE	DESCRIPTION	
A	03.08.05	NEW ISSUE	
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

RELEASED

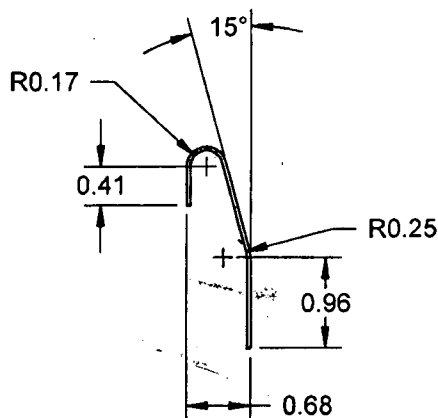
06.11.20 [Signature]



D3199-1 FLAT PATTERN



D3199-1 BRACKET



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) **ANNEALED**
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33672*

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